

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-775 REV. A  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-775 REV. 0

REF. TCCA STC SH08-53  
REF. FAA STC SR02692NY  
REF. EASA STC EASA.IM.R.S.01529

It has come to Dart's attention that due to variances in airframe, the D3608-1/-3 Lower/Upper Doublers of the D412-775-013 Step Protective Trim Kit at CHG 001 may not always fit as intended. To ensure proper fit, Dart has made changes to both D3608-1/-3 Doublers at CHG 002 and later. The manuals listed above are amended as follows:

## IS:

### INSTALLATION INSTRUCTIONS IIN-D412-775 REV. A, SECTION 3.2

3.2.5 Locate the D3608-1/-3 Doublers per Figure 3 and 4 and transfer drill #28 ( $\phi 0.141$ " ) holes from the aircraft to the D3608-1/-3 Doublers. Bend tabs on D3608-1/-3 Doublers as shown in Figure 1 of this service instruction and trim rectangular opening as required to fit airframe.

**NOTE:** To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

### INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-775 REV. 0, SECTION 53.4

53.4.2 Locate the D3608-1/-3 Doublers per Figure 53-2 and 53-3. If the D3608-1/-3 doublers are being replaced, transfer drill #28 ( $\phi 0.141$ " ) holes from the aircraft to the D3608-1/-3 Doublers. Bend tabs on D3608-1/-3 Doublers as shown in Figure 1 of this service instruction and trim rectangular opening as required to fit airframe.

**NOTE:** To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

## WAS:

### INSTALLATION INSTRUCTIONS IIN-D412-775 REV. A, SECTION 3.2

3.2.5 Locate the D3608-1/-3 Doublers per Figure 3 and 4 and transfer drill #28 ( $\phi 0.141$ " ) holes from the aircraft to the D3608-1/-3 Doublers.

**NOTE:** To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

### INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-775 REV. 0, SECTION 53.4

53.4.2 Locate the D3608-1/-3 Doublers per Figure 53-2 and 53-3. If the D3608-1/-3 doublers are being replaced, transfer drill #28 ( $\phi 0.141$ " ) holes from the aircraft to the D3608-1/-3 Doublers.


**NOTE:** To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

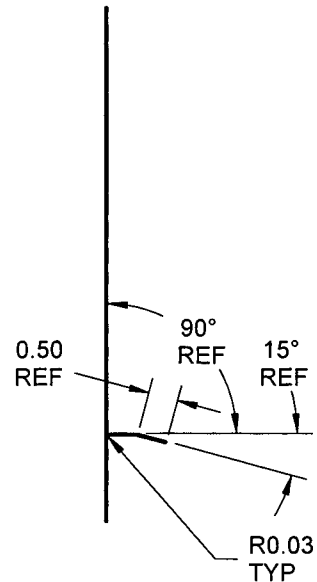
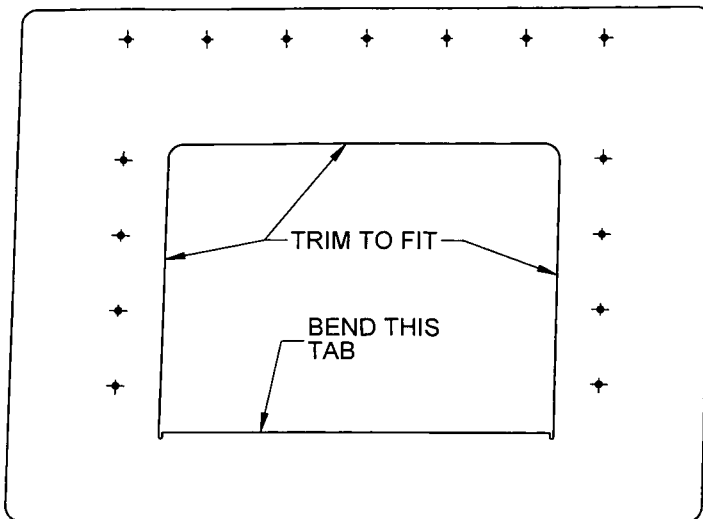
CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

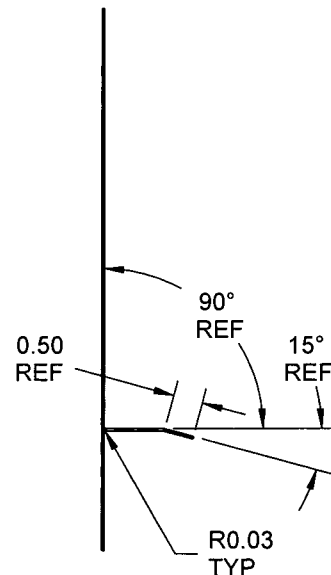
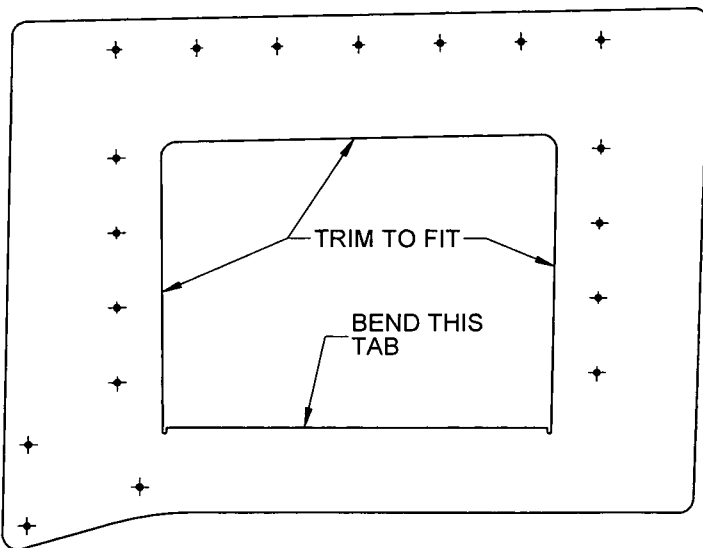
BY:   
D. SHEPHERD (DE # 02)

DATE: 10.02.05  
CERT. NO.: SH08-53  
ISSUE NO.: 1

A	NEW ISSUE	MB	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9503	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP PROTECTIVE TRIM CHG	NTS
DATE	10.02.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**D3608-3 BENT UPPER DOUBLER**



**D3608-1 BENT LOWER DOUBLER**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 10.02.05  
CERT. NO.: SH08-53  
ISSUE NO.: 1

**FIGURE 1: TRIMMING/BENDING OF D3608-1/-3 DOUBLERS**  
(PARTS SHOWN PRIOR TO TRANSFER DRILLING)

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9503	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STEP PROTECTIVE TRIM CHG	NTS
DATE	10.02.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	